

Date: Friday, 30/05/2008 10:13:14 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	INNER AFT SADDLE	
<b>Job Number</b> :	39606	<b>Part Number</b> :	D5957	
<b>Estimate Number</b> :	11082	<b>Drawing Number</b> :	D5957.REVB	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	30/05/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	B	
<b>First Issue</b> :	/ /	<b>Type</b> :	MACHINED PARTS	
<b>Previous Run</b> :	39510	<b>Material</b> :		
<b>Written By</b> :		<b>Due Date</b> :	15/06/2008	<b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<u>JUL 08.5.30</u>			
<b>Comment</b> :	Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: B34873

DIP 08/06/03

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

DIP 08/06/04 / LF 08/06/05

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

DIP 08/06/04 / LF 08/06/05

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JL 08/06/05

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

2P / FL 08/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:13:15 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 39606

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M107925



6X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00  
320 °F  
9:30

M-1

08/06/09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/06/09

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 42

AS 08/06/09

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



C208/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	39606
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.442	.441	.441	.441		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.001	7.001	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.749	4.750	4.7485	4.7485		
G	0.315	0.322		0.322	0.322	0.322	0.322		
H	1.522	1.532		1.525	1.526	1.527	1.527		
I	3.048	3.058		3.052	3.054	3.053	3.053		
J	4.575	4.585		4.580	4.579	4.580	4.580		
K	0.313	0.318		0.318	0.318	0.318	0.318		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.500	0.500	0.500	0.501		
N	1.865	1.885		1.879	1.879	1.878	1.875		
O	7.990	8.010		8.000	8.007	8.000	8.000		
P	2.240	2.260		2.240	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		0.494	.500	.500	.500		
T	1.625	1.645		1.6385	1.6375	1.639	1.639		
U	2.000	2.020		2.003	2.003	2.004	2.004		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJP  
Date: 08/06/04 / 08/06/05

Audited by: JL  
Date: 08/06/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39604
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

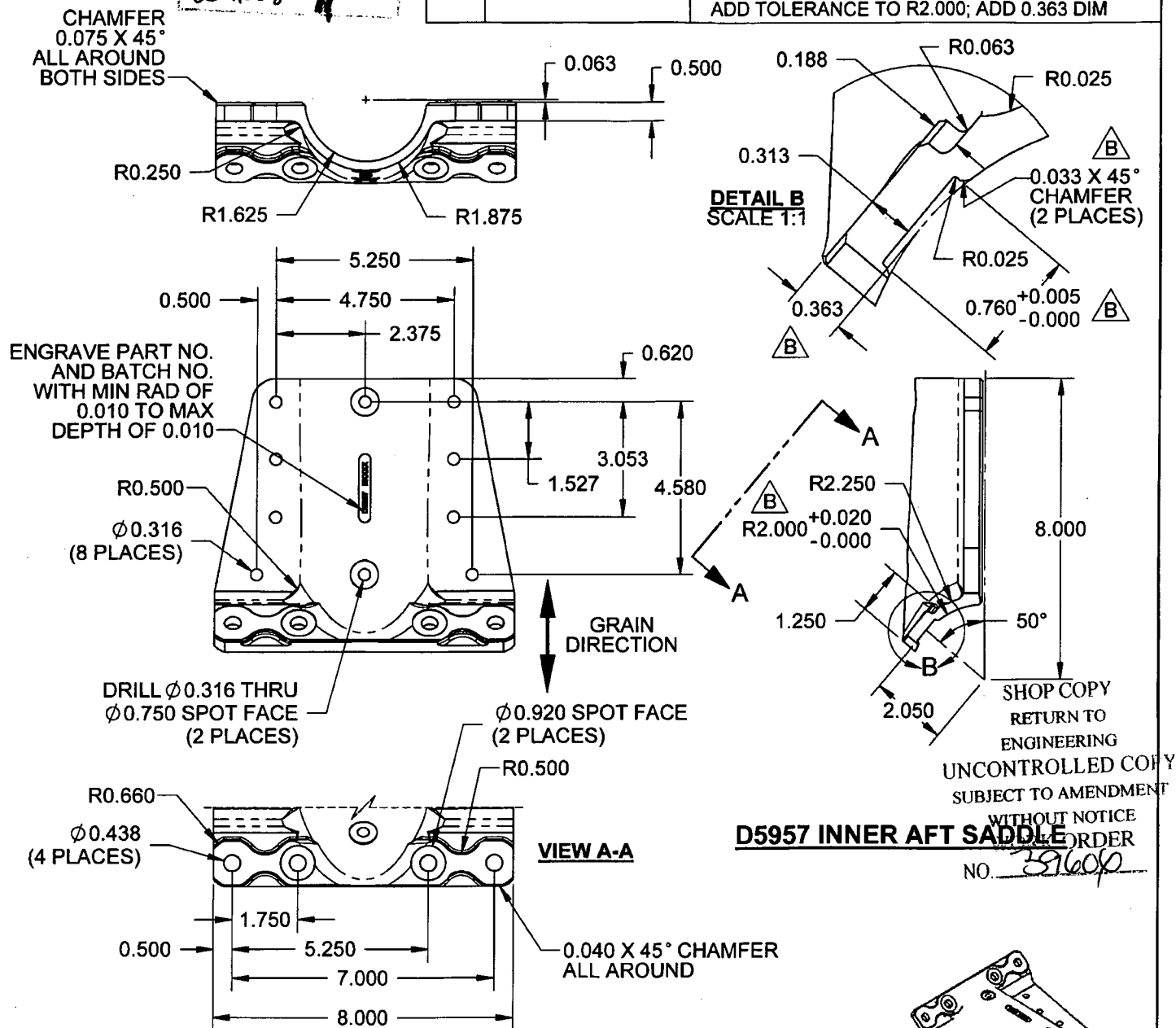
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	3	4		
A	0.438	0.443		.441	.441				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.749	4.750				
G	0.315	0.322		0.322	.321				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.054	3.054				
J	4.575	4.585		4.580	4.580				
K	0.313	0.318		0.318	.318				
L	0.495	0.505		0.500	.500				
M	0.490	0.510		0.505	.500				
N	1.865	1.885		1.880	1.875				
O	7.990	8.010		7.999	7.995				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.310	.310				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.500	.500				
T	1.625	1.645		1.635	1.635				
U	2.000	2.020		2.010	2.007				
V	0.023	0.043		.033	.033				
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>SP</i>	Audited by: <i>JL</i>
Date: 08/08/05	Date: 08/06/05

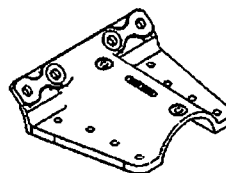
Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5957</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER AFT SADDLE</b>		SCALE 1:4
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>	
<b>B</b>	<b>06.11.07</b>	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**  
SCALE 1:8

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